

Date: Friday, 07/07/2006 8:59:14 AM
 User: Linda Lacelle

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------------------|------------------------|------------------|---------------|-----|------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SPACER KIT | | |
| Job Number | : 27584 | | Part Number | : D25253 | | |
| Estimate Number | : 11800 | | Drawing Number | : D2525 REV B | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 07/07/2006 | S.O. No. : N/A | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : 15/06/2006 | Type : PURCHASED PARTS | Due Date | : 30/06/2006 | | |
| Previous Run | : N/A | | Qty: | 20 | Um: | Each |
| Written By | : <u>See comment below</u> | | | | | |
| Checked & Approved By | : <u> </u> | | | | | |
| Comment | : Est. B99.11.10 Re-format added Acid etch stepEC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | | |
|-----------------------------------------------------------------------------------------------|-----------------------|----------------------------------------|-----------------|-----------------|------------|
| 1.0 | M6061T6R0750 | 6061-T6 Round Bar .750" | | | |
| Comment: Qty.: 0.0220 f(s)/Unit Total : 0.4400 f(s) 6061-T6 Round Bar .750" <i>M100157</i> | | | <i>STO</i> | <i>06/07/11</i> | |
| 2.0 | LATHE CONV. | CONVENTIONAL LATHE | | | |
| Comment: CONVENTIONAL LATHE <i>STO</i> | | | <i>06/07/11</i> | <i>20</i> | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>STO</i> | | | <i>06/07/11</i> | <i>20</i> | |
| 4.0 | QC8 | SECOND CHECK | | | |
| Comment: SECOND CHECK <i>STO</i> | | | <i>06/07/11</i> | <i>20</i> | |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 | | | |
| Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>SAD</i> | | | <i>06/07/11</i> | <i>20</i> | |
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP | | | |
| Comment: INSPECT WORK TO CURRENT STEP <i>STO</i> | | | <i>06/07/13</i> | <i>20</i> | <i>PRO</i> |

| Date | Step | By | Date | Qty |
|----------|------|----------------------------------------|------|----------|
| 06-07-13 | 6 | QC 3 for stockline. Perm. Change. J | E | 06-07-25 |

Date: Friday, 07/07/2006 8:59:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27584

Part Number: D25253

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST47

16/7/15 (20)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

16.06.07.17

Job Completion



U 16.07.15

Date: Thursday, 6/15/2006 1:50:32 PM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|------------|-------------------------------------------------|---------------|--|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SPACER KIT | | |
| Job Number | : 27584 | | Part Number | : D25253 | | |
| Estimate Number | : 11800 | | Drawing Number | : D2525 REV B | | |
| P.O. Number | : | | Project Number | : N/A | | |
| This Issue | : 6/15/2006 | S.O. No. : | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | Material | : | | |
| First Issue | : / / | Type | : PURCHASED PARTS | | | |
| Previous Run | : | | Due Date | : 6/30/2006 | | Qty: 20 Um: Each |
| Written By | : | | See Replaced w/o attached | | | |
| Checked & Approved By | : | | | | | |
| Comment | : | | Est. B99.11.10 Re-format added Acid etch stepEC | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|-------------------------------------------------------------------|
| 1.0 | PG | PURCHASING |
| | | <i>Material:</i> |
| | | <i>6061-T6 Ø.750"</i> <i>(.022 Feet)</i> |
| | | <i>Issue P/O: _____</i> |
| | | <i>Make as per Dwg D2525</i> |
| | | <i>Material release note required</i> |
| | | <i>Batch: _____</i> |
| 2.0 | D2525P | Spacer Kit |
| | | <i>Conventional Lathe.</i> |
| | | <i>Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)</i> |
| | | <i>Spacer Kit</i> |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | <i>QC2</i> |
| | | <i>Comment: PACKAGING RESOURCE #1</i> |
| | | <i>Recieve & Inspect for Transit Damage</i> |
| | | <i>Ensure Material Release Note is attached</i> |
| 4.0 | QC5 | DIMENSIONAL CHECK |
| | | <i>QC8</i> |
| | | <i>Comment: DIMENSIONAL CHECK</i> |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | <i>Comment: HAND FINISHING RESOURCE #1</i> |
| | | <i>Acid etch and Alodine as per QSI 005 4.1</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:50:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER KIT

Job Number: 27584

Part Number: D25253

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

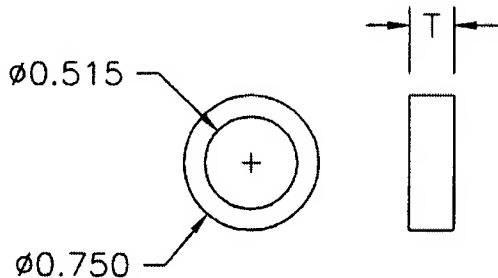
DART

| | | |
|------------------|----------------|---------------------------------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED KE | APPROVED H | DRAWING NO. D2525 |
| DATE 99.09.30 | | TITLE SPACER KIT |
| | | SCALE 1:1 |
| A | 95.12.22 | NEW ISSUE |
| B | 99.09.30 | REVISED MATERIAL |

RELEASED

99.10.12 KE

| PART NUMBER | THICKNESS T | QTY |
|-------------|-------------|-----|
| D2525-1 | 0.750 | 1 |
| D2525-3 | 0.250 | 1 |
| D2525-5 | 0.125 | 4 |
| D2525-7 | 0.063 | 0 |
| D2525-9 | 0.032 | 0 |



MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/11)
 OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27584

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27584 |
| Description: SPACER | Part Number: | D25253 |
| Inspection Dwg: D2525 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

| | | | | | |
|--------------|-------------------------------------------------------------------------------------|-------------|----------|---------------------|---|
| Measured by: |  | Audited by: | SD | Prototype Approval: | — |
| Date: | 06/07/11 | Date: | 06.07.11 | Date: | — |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |